

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009042**Date Inspected:** 11-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1945**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (South of the Blast Shop)

Segment 6BW

This QA Inspector performed Magnetic Particle testing (MT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the deck panel diaphragm to U-Rib attachment welds. The Weld Designations are as follows:

DP112-001-053~057 and 095~099.

DP139-001-053~057 and 095~099.

DP193-001-053~057, 095~099 and 137~141.

DP220-001-053~057, 095~099 and 137~141.

DP247-001-053~057, 095~099 and 137~141.

DP274-001-031~035 and 57~61.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the longitudinal diaphragm to Floor beam and bottom plate welds. The Weld Designations are as follows:

SEG029B-018, 019, 024 and 025.

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SEG029C-018, 019, 024 and 025.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the floor beam component welds. The Weld Designations are as follows:

SSD9B-PP41-003, 004, 041~046, 047~052 and 099~104.

SSD30D-PP41.5-079~084

SSD9B-PP42-003, 004, 041~046, 047~052 and 099~104.

SSD30D-PP42.5-079~084

SSD9B-PP43-003, 004, 041~046, 047~052 and 099~104.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the corner assembly component welds. The Weld Designations are as follows:

CA013-011, 012, 017, 018, 023 and 024.

CSD8-PP41-011, 012 and 041~044.

CSD8-PP42-011, 012 and 041~044.

CSD8-PP43-011, 012 and 041~044.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the floor beam sub-assembly welds. The Weld Designations are as follows:

FB003-055-004 and 005.

FB003-033-004 and 005.

FB003-045-004 and 005.

FB015-011-001 and 002.

FB009-005-003 and 004.

FB015-014-001 and 002.

FB015-006-001 and 002.

FB009-003-003 and 004.

During random verification Magnetic Particle Testing of the internal components of OBG segment 6BW, Caltrans Quality Assurance (QA) Inspector discovered a total of one (1) transverse and three (3) longitudinal linear indications that measured from 5mm to 70mm in length. These welds were previously tested accepted by ZPMC (MT) technicians. See Incident Report on this date.

The affected weld designations are as follows;

Deck panel diaphragm to floor beam flange weld-SSD9B-PP41-004 (1) 5mm Transverse Indication.

FL2-1 floor beam web to flange weld at panel point 43 Weld-FB003-045-004 (2) 70mm Longitudinal Indications.

FL2-1 Floor Beam web to flange weld at Panel Point 43 Weld-FB003-045-005 (1) 50mm Longitudinal Indication.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

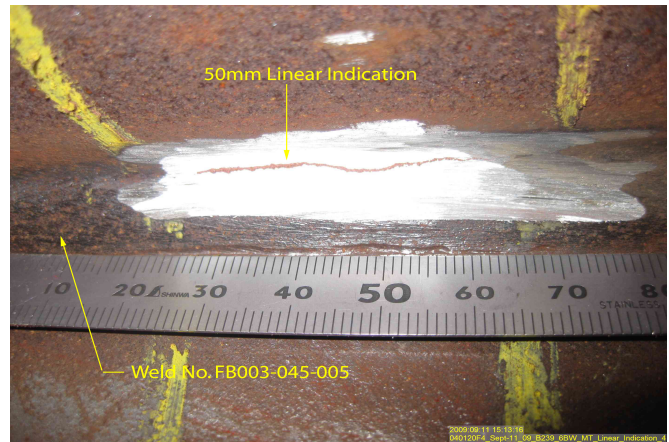
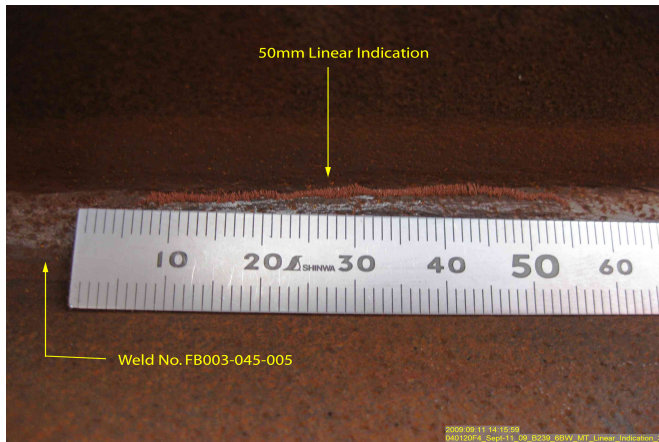
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No Relevant conversations



### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, (15000422372), who represents the Office of Structural Materials for your project.

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**Inspected By:** Patterson,Rodney

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer

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